

Work Order ID 60028

Tuesday, June 22, 2010 3:26:02 PM



Page 1

Item ID: D4047-5

Accept



Setup Start



Revision ID:

Item Name: Rib

Stop



Start Date: 6/22/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 7/30/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: *H*Date: *10-6-22* Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run

Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4047

A

100

0.00



Large Fab

Memo

0.00

Large Fab

1- Cut as per dwg D4047

2- Deburr and remove identification markings

SAD 10-06-24

②

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

SAD 10-06-24

②

120

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

WA

SAD

10-06-24

②

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Accept

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Item Name: Rib

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Required Date: 7/30/2010 Req'd Qty: 2.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Setup Start

Stop

Cust Item ID:

Customer:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/28

CZ10/6/25

Dart Aerospace Ltd

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Picklist Print

Tuesday, June 22, 2010 3:26:07 PM

Page 1

Work Order ID: 60028

Parent Item: D4047-5

Parent Item Name: Rib



Start Date: 6/22/2010

Required Date: 7/30/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP RevA: new issue DD 10/01/06 verified by:EC IPP RevB: as per dwg
revA DD 10.02.18 verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304TS0.500W.049

Purchased

No

100

f

155.2554

5.208

10.96421



Square Tubing



SAD 10-06-29

Location

Loc Qty

Loc Code

MAT

148.1591158

114004

0

114426

9.2647

114807

138.894416

MAT018

4.4738

114004

0.5

114161

3.9738

WA

2.62251

114724

2.62251

10.96421

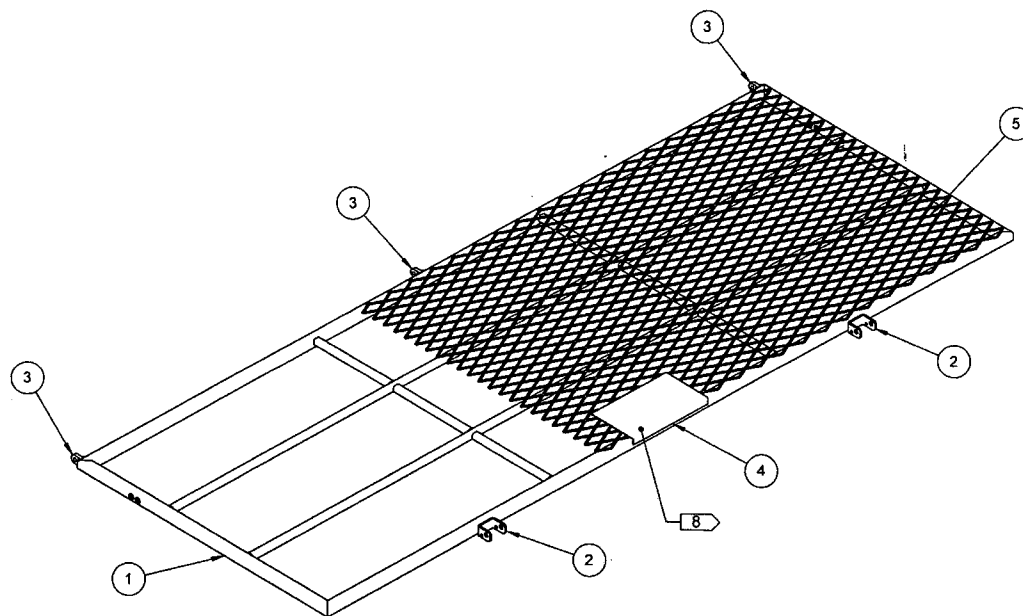
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NOTE: Date & initial all entries



D4047-041 SHORT BASKET LID ASSY
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 14.17 lbs APROX
- 8) APPL BLACK ANTI-SKID PAINT TO TOP SURFACE OF MESH, EXCEPT ON D4021-3 LABEL PLATE PER DART QSI 005 4.4

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4047-041	SHORT BASKET LID ASSY
1	1	D4047-101	LID FRAME ASSY
2	2	D2581	MOUNTING BRACKET
3	3	D4016-3	HINGE HALF, LID
4	1	D4021-3	LABEL PLATE
5	1	D4046-7	MESH

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 60028

BS106-22

RELEASED

2010-02-16

WNP

A	NEW ISSUE	RF	10.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	<i>RF</i>		
MFG. APPR.	<i>RF</i>		
APPROVED	<i>RF</i>		
DE APPR.	<i>RF</i>		
DATE	10.01.29		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D4047

REV. A
SHEET 1 OF 6

TITLE
SHORT BASKET LID ASSY

SCALE
NTS

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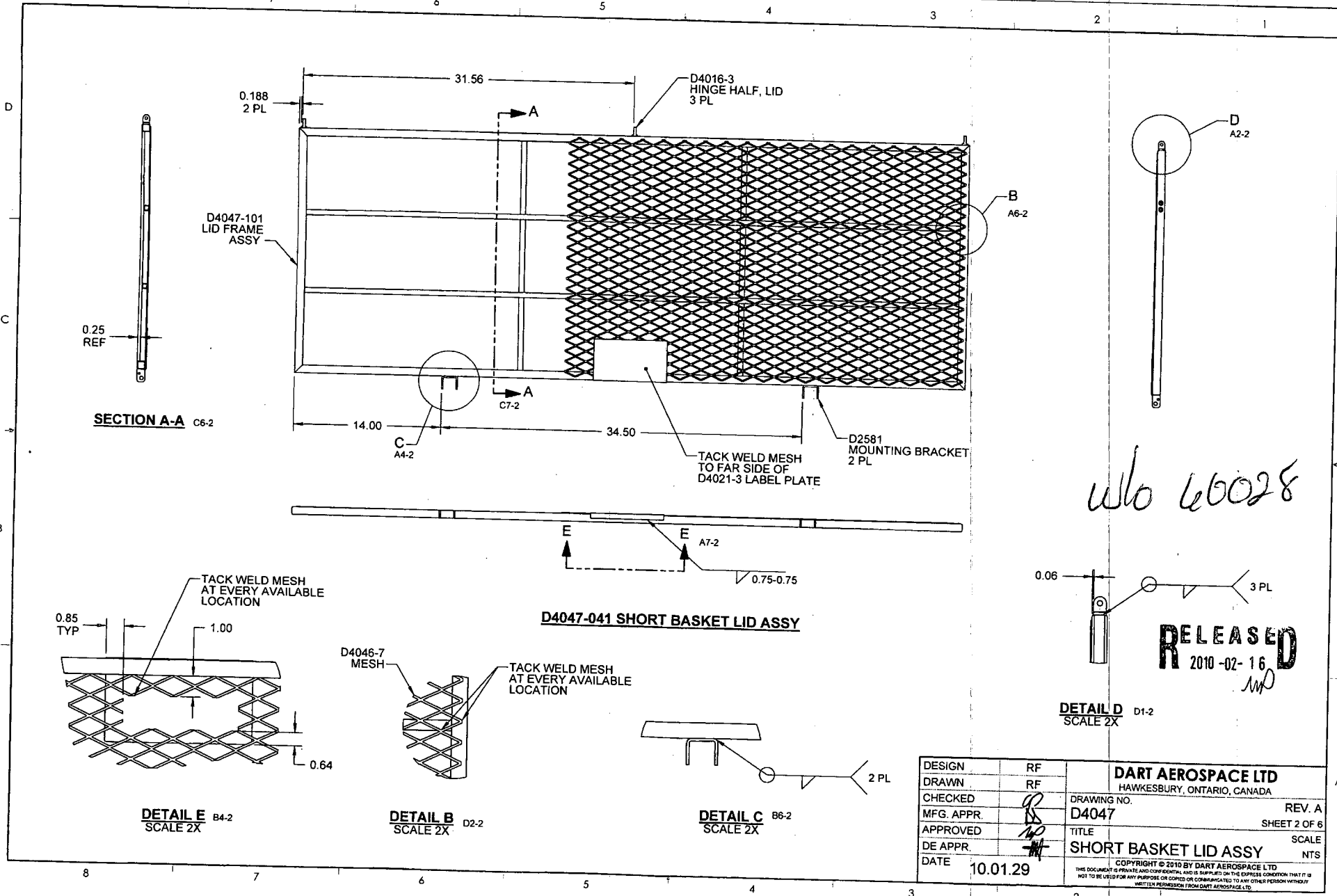
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4047	SHEET 2 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SHORT BASKET LID ASSY	NTS
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W/O:		WORK ORDER CHANGES					
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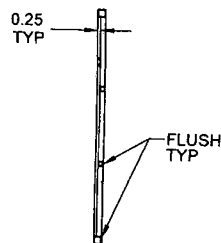
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

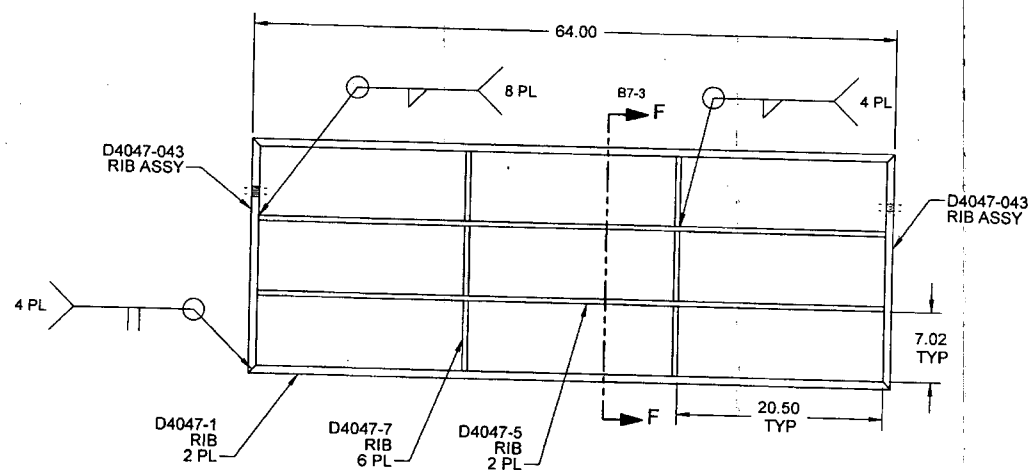
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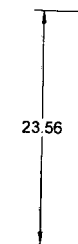
ITEM	QTY -101	P/N	DESCRIPTION
	X	D4047-101	LID FRAME ASSY
1	2	D4047-043	RIB ASSEMBLY
2	2	D4047-1	RIB
3	2	D4047-5	RIB
4	6	D4047-7	RIB



SECTION F-F C4-3



D4047-101 LID FRAME ASSY



w/o 60028

RELEASED
2010-02-16
MD

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 10.33 lbs
 - 8) WELD PER DART QSI 004

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>92</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>18</i>	D4047	SHEET 3 OF 6
APPROVED	<i>140</i>	TITLE	SCALE
DE APPR.	<i>TH</i>	SHORT BASKET LID ASSY	NTS
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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

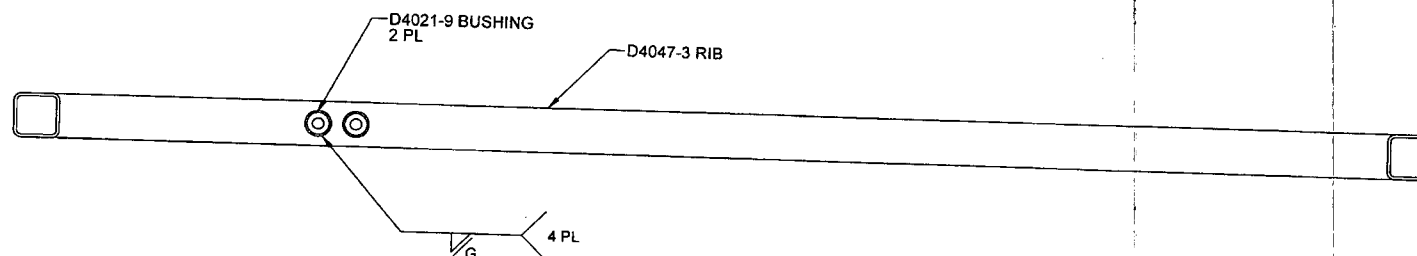
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -043	P/N	DESCRIPTION
	X	D4047-043	RIB ASSEMBLY
1	1	D4047-3	RIB
2	2	D4021-9	BUSHING



D4047-043 RIB ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.88 lbs
- 8) WELD PER DART QSI 004

RELEASED
2010-02-16
MP

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DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	RF	D4047	SHEET 4 OF 6
APPROVED	RF	TITLE	SCALE
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NOTE: Date & initial all entries

0.75
REF

62.50

64.00

D4047-1 RIB

45°
2 PL

5.04 0.625 0.75 REF
0.38
Ø0.375 2 PL, THRU
Ø0.435 x 45° CAMFER, 4 PL

22.06

23.56

D4047-3 RIB

45°
2 PL

w/o 60028

RELEASED
2010-02-16
MD

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 x 0.75 x 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D4047-1: 2.63 lbs
D4047-3: 0.84 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	Q		DRAWING NO. D4047
MFG. APPR.	S		TITLE SHORT BASKET LID ASSY
APPROVED	MD		REV. A SHEET 5 OF 6
DE APPR.	MD	SCALE NTS	
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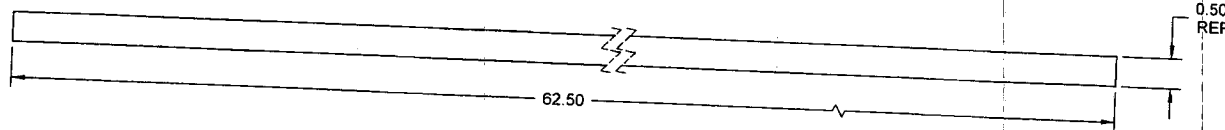
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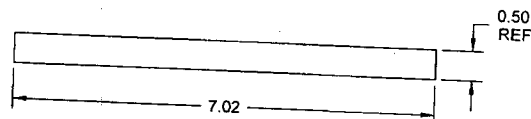
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D4047-5 RIB



D4047-7 RIB

W00028

RELEASED
2010-02-16

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 x 0.50 x 0.049 WALL
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D4047-5: 1.44 lbs
D4047-7: 0.16 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>RF</i>	DRAWING NO. D4047	REV. A
MFG. APPR.	<i>RF</i>	TITLE	SHEET 6 OF 6
APPROVED	<i>RF</i>	SHORT BASKET LID ASSY	SCALE NTS
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